














Date: Tuesday, 9/4/2007 11:29:25 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INLET VALVE SHAFT	
Job Number : 34391		
Estimate Number : 12251		
P.O. Number : N/A	Part Number : D34745	
This Issue : 9/4/2007 S.O. No. : N/A	Drawing Number : D3474 REV.A	
Prsht Rev. : NC	Project Number : N/A	
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A	
Previous Run : 29457	Material : N/A	
Written By : _____	Due Date : 10/4/2007 Qty: 6 Um: Each	
Checked & Approved By : <u>HJ 07-09-04</u>		
Comment : est rev. A 06.04.20 New issue EC		
<b>Additional Product</b>		
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
		
Comment: Qty.: 0.0525 sf(s)/Unit Total : 0.3150 sf(s) 304/316 0.018 SHEET M10S490 HB 07-09-06		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET Cut as per Dwg D Dwg Rev: <u>A</u> Prog Rev: <u>A</u> HB 07-09-06 (6)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-09-06		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <del>HB 07-09-06</del> SB 07/09/06 (X6) counter		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Debur if necessary. SMO 07/09/06 (6)		
6.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP SB 07/09/11		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/09/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:29:25 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET VALVE SHAFT

Job Number: 34391

Part Number: D34745

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 100

*EP 07/09/11 (6)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*EP 07/09/11 (6)*

Job Completion



*U 07-09-11*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

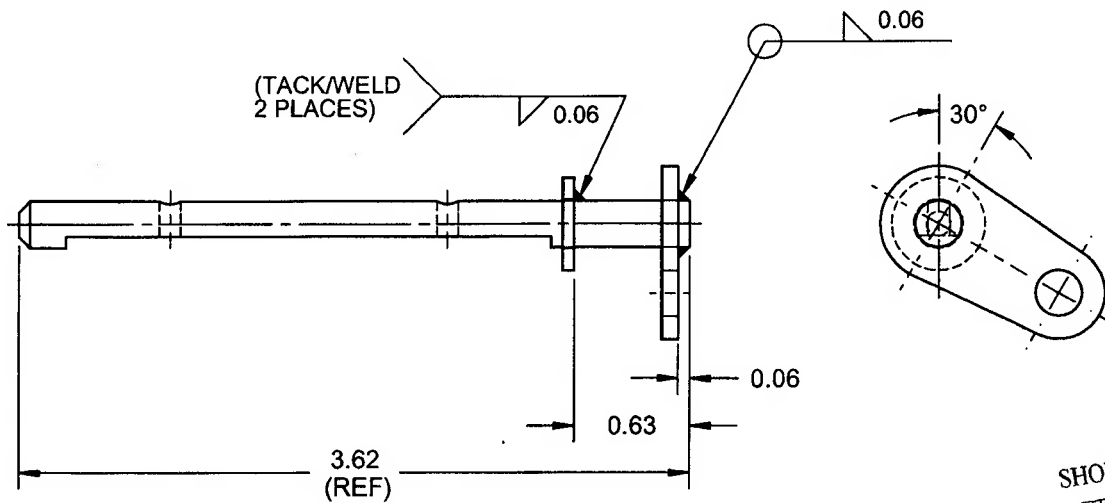
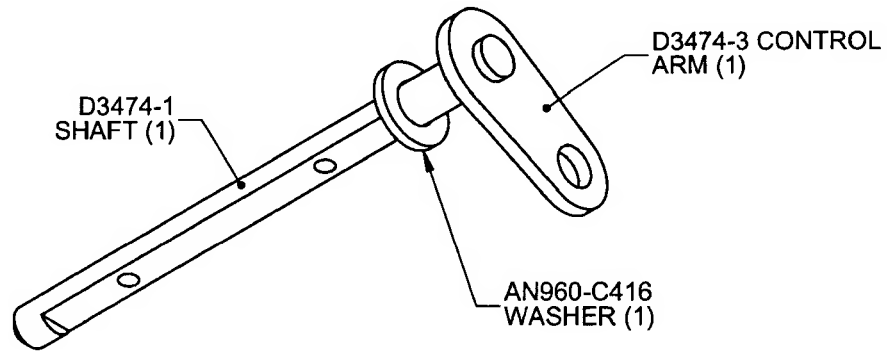
**NOTE:** Date & initial all entries





**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3474</b>	REV. A SHEET 1 OF 4
DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1
A	06.01.23	NEW ISSUE	

*[Signature]* 06.04.03**D3474-041 INLET VALVE SHAFT**

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WITHOUT NOTICE  
WORK ORDER  
NO. *34391*

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

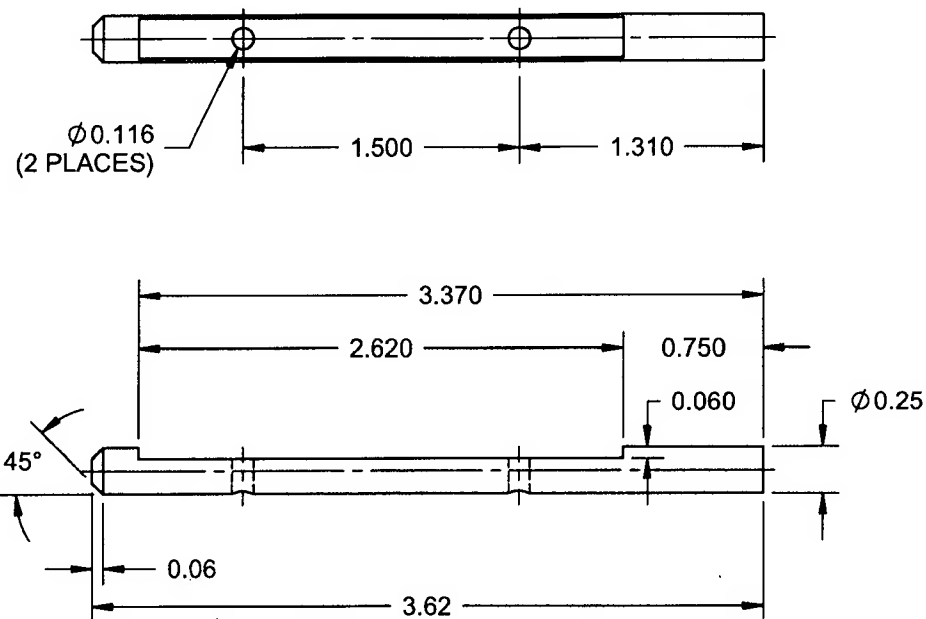
QTY -041	P/N	DESCRIPTION
X	D3474-041	INLET VALVE SHAFT
1	D3474-1	SHAFT
1	D3474-3	CONTROL ARM
1	AN960-C416	WASHER

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3474</b>	REV. A SHEET 2 OF 4
DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1

*[Signature]* 06-04-03**D3474-1 SHAFT****NOTES:**

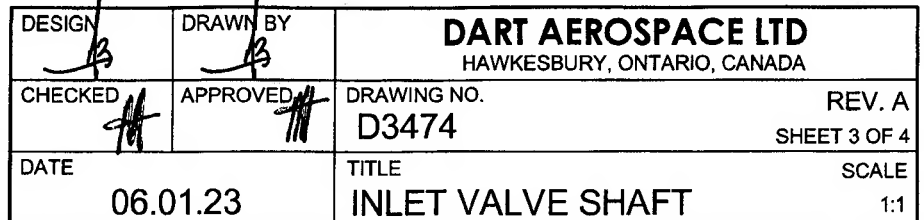
- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR  
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Technical drawing of a vertical rectangular plate. The drawing shows a side view of the plate with a vertical dimension line on the right indicating a height of 1.31 (REF). A horizontal dimension line at the bottom indicates a width of 0.09 (REF). The plate is represented by two parallel vertical lines, with the top and bottom edges slightly rounded or chamfered.

Technical drawing of a circular part with the following dimensions and labels:

- Overall width: 1.500
- Overall height: 1.450
- Overall diameter: 2.580
- Distance from center to left edge: 0.750
- Distance from center to right edge: 0.750
- Distance from center to bottom edge: 0.750
- Distance from center to top edge: 0.750
- Label:  $\varnothing 0.116$  (2 PLACES)
- Label: **LVE**
- Label: **E**
- Label: **C.**

0.018  
(REF)

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WORK ORDER  
3439

2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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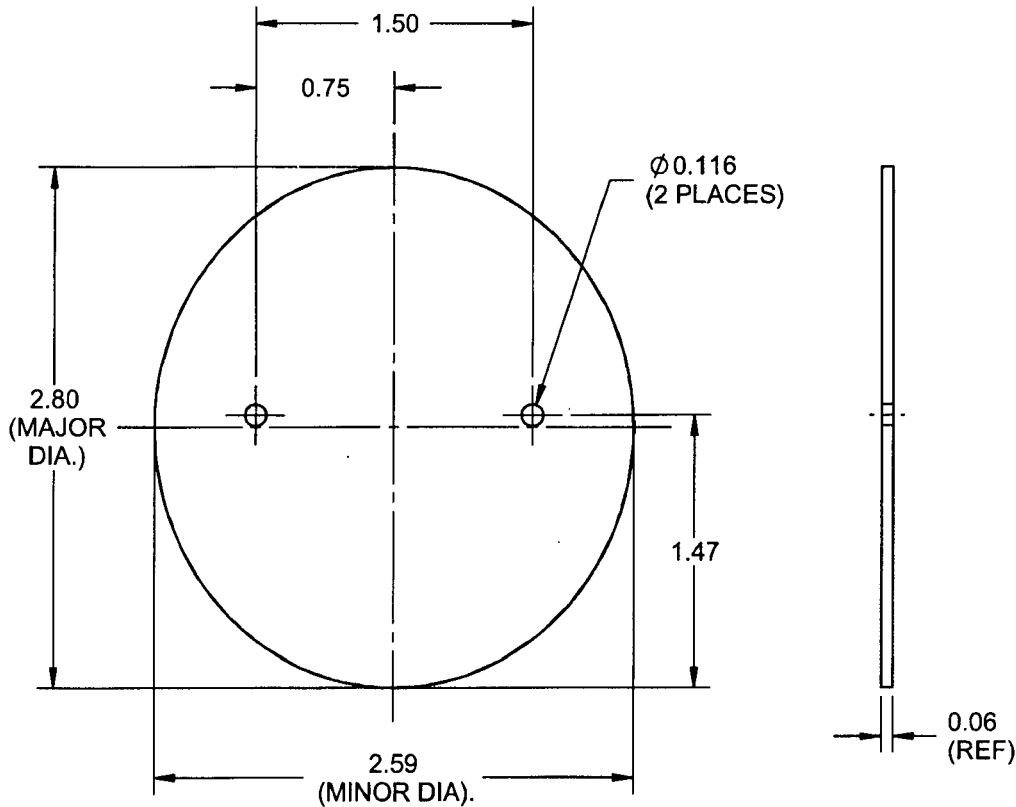
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[illegible]

**DART**

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3474	REV. A SHEET 4 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

# 06.04.03

**D3474-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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